

Date: Monday, 09/02/2009 4:30:28 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLADE POSITIONER	
Job Number :	45650			
Estimate Number :	13530			
P.O. Number :		Part Number :	PB674300127	
This Issue :	09/02/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	B6743001 P.4	
First Issue :	//	Project Number :	N/A	
Previous Run :	43064	Drawing Revision :	B1	
Written By :		Material :		
Checked & Approved By :	<u>MF 09-08-23</u>	Due Date :	18/03/2009	Qty: 2 Um: Each
Comment :	Est Rev:A 08-07-29 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec			

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PB674300135

PB67-43001-35 Lower Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-35 Lower Pad Assembly

batch: 41378MF 09-03-03

2.0

PB674300131

PB67-43001-31 Upper Restraint Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-31 Upper Restraint Weldment

batch: 41377MF 09-03-03

3.0

PB674300129

PB67-43001-29 Blade Positioner Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-29 Blade Positioner Weldment

batch: B45032MF 09-03-03

4.0

PB6743001285

PB67-43001-285 Upper Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-285 Upper Tube

batch: 4494MF 09-03-03

5.0

PB674300119

PB67-43001-19 Inner Tube and Retainer Bu



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PB67-43001-19 Inner Tube and Retainer Bu

batch: 45039MF 09-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:28 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45650

Part Number: PB674300127

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB6743001293	Extension Tube Adjustmnt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Extension Tube Adjustmnt
batch: B44971

MF 09-03-03

7.0	PB6743001289	Handle Adjustmnt Fitting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Adjustmnt Fitting
batch: B46246

MF 09-03-03

8.0	PB6743001291	Clamp Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp Bushing

40060 MF 09-03-03

9.0	AN622A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m110155

MF 09-03-03

10.0	AN960JD10	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch: m110139

MF 09-03-03

11.0	NAS1149F0632P	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m18057

MF 09-03-03

12.0	MS518598	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: MS1 m108986

MF 09-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:28 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45650

Part Number: PB674300127

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	MS21042L6	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: m108183

MF 09-03-03

14.0	MS27039109	Screw
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

batch: m107378

MF 09-03-03

15.0	NAS1149F0316P	WASHER
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

WASHER

batch: m109031

MF 09-03-03

16.0	MS27039104	Inventory
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Inventory

batch: m18431

MF 09-03-03

17.0	MS24694S102	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: m14604

MF 09-03-03

18.0	AN526A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m18057

MF 09-03-03

19.0	NAS1149F0532P	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

m18057

MF 09-03-03

Dart Aerospace Ltd

W/O: 45650		ESTIMATE: 13530		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.03.05	17.0 18.0 19.0 20.0 21.8	REMOVE STEPS. NOT APLICABLE. PERMANENT CHANGE	Done By David Duran	08.12.04 09.03.12		09.03.07	09.03.12	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:30:28 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE POSITIONER

Job Number: 45650

Part Number: PB674300127

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

batch: m110382

MF 09-03-03

21.0

MS518598

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

batch: m108986

MF 09-03-03

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- slide -289, -291 and -293 on -19 tube then slide it in -285 tube

2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg

3- assemble all parts as per dwg PB67-43001

FL 09/03/05

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/3/5

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Blade Fold section

MF 09-03-12

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/12

Job Completion



MF 09-03-12

Dart Aerospace Ltd

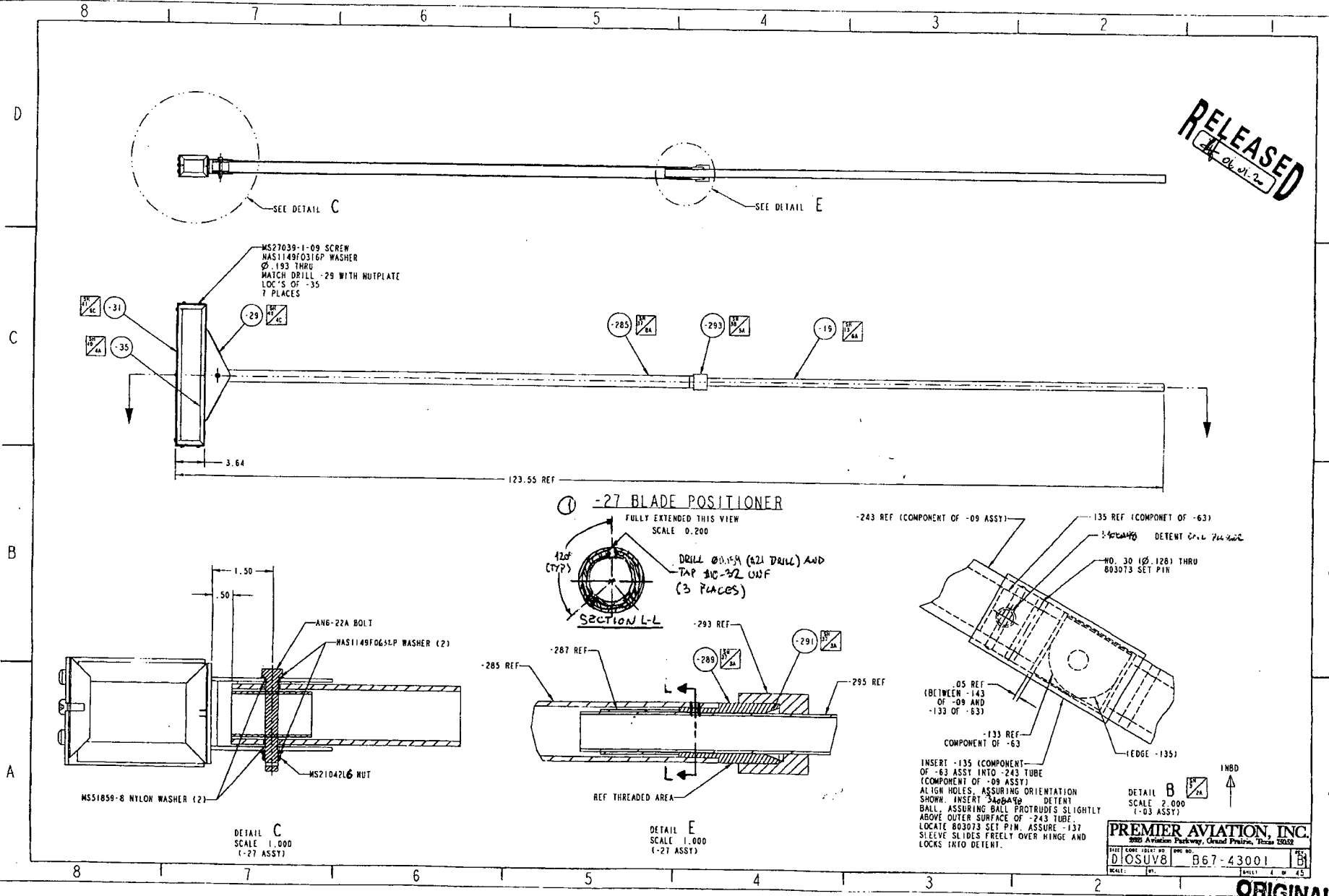
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-27 PAR #: N/A Fault Category: Prod / FAB NCR: Yes No DQA: D Date: 09/03/10
 Resolution: REWORK Disposition: REWORK QA: N/C Closed: D Date: 09/03/10

NCR: <u>45650</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.04.05	22.0	CONTACT CEMENT OVERSPILT ON EXPOSED SURFACE OF B67-43001-35. R.C. IMPROPER USE OF CONTACT CEMENT.	09.04.05	TRY CLEANING OFF CONTACT CEMENT. SCRAP PART IF NOT SUCCESSFUL Clean off the glue, with wash n wipe 41055.	FL 02/03/05. Cpl 09.03.05	S 09/03/05	09.04.05	S 09/03/05

NOTE: Date & initial all entries

RELEASED
44 JUL 22



PREMIER AVIATION, INC.
 2880 Aviation Parkway, Grand Prairie, Texas 75052

FIG. NO. 867-43001
 SCALE: 1/16" = 1" (1-03 ASSY)
 SHEET 4 OF 45

ORIGINAL

#45033